

Work Order ID 112998

Tuesday, February 11, 2014 1:47:28 PM

112998

Page 1

Item ID: PB67-43001-115

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube End Plate

Start Date: 2/11/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MF. Date: 14-2-11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

00001, 250

8 0 Jm14-02-16

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

8 0 Jm14-02-16

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Smp
14/2/19

8 _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
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		☐ Over/Under tolerance
		☐ Part Incorrect
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		☐ Temperature/Cure
		☐ Weld
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		☐ Other

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Page 2

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo ME222	0.00						DAS 32 9-89	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

17/2/20

14-02-20

14-02-20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

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Page 1

Work Order ID: 112998

Parent Item: PB67-43001-115

Parent Item Name: Tube End Plate

Start Date: 2/11/2014

Required Date: 2/28/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.08.26New issueKJ/JLM
IPP Rev:B 08-06-19 now made water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

~~M6061T6B0.250X06.000~~

~~6061-T6 Bar .250 x 6.00~~

Purchased

No

100

f

112.1100

0.0542

1

Jm 14-02-16

Location

Loc Qty

Loc Code

MAT051

112.11

121040

0.15

123279

14.56

125386

16.66

125390

3.74

m126647

77

m6061T6B0.250

3th
B

125024

125024

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

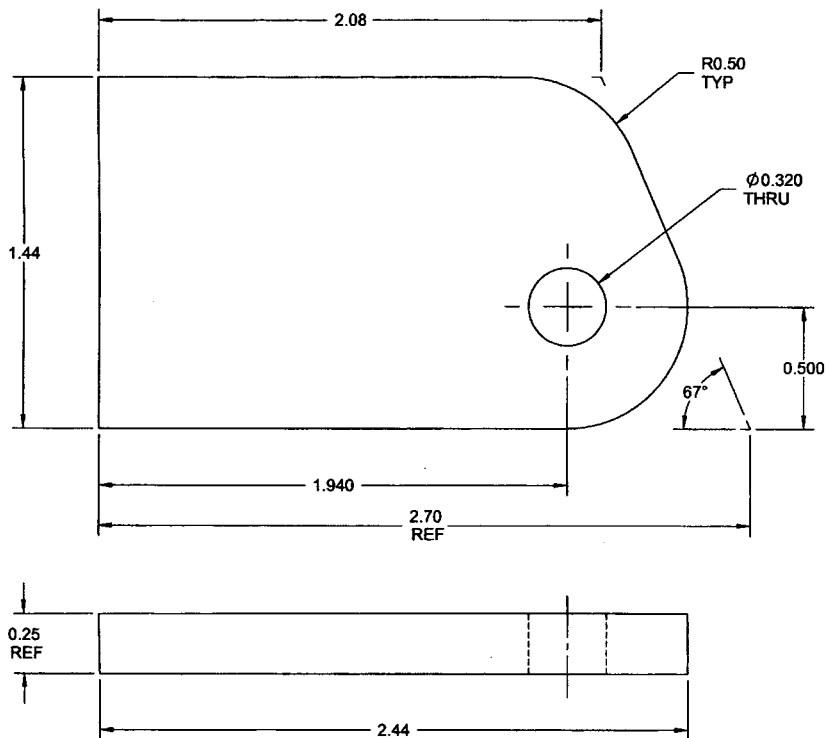
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FAULT CATEGORY

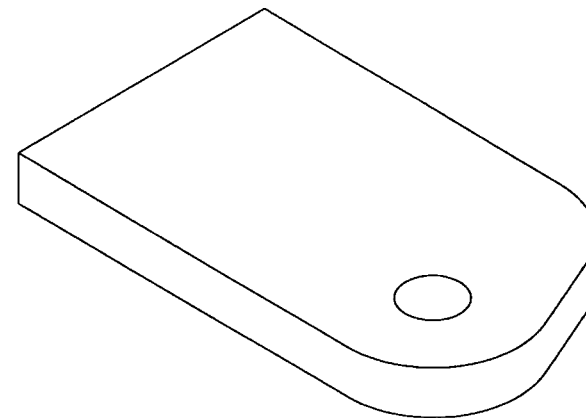
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		☐ Temperature/Cure
		☐ Weld
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		☐ Other



B67-43001-115 TUBE END PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.250
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B0.250
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs



112998
11-02-11

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 32 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#03-011.		MB	09.03.02
REV.	DESCRIPTION		BY	DATE
DESIGN	RW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RW		REV. C	
CHECKED	RW		DRAWING NO. B67-43001-115	
MFG. APPR.	RW		SHEET 1 OF 1	
APPROVED	RW		TITLE TUBE END PLATE	
DE APPR.	N/A		SCALE NTS	
DATE	09.03.02		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

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